

Split

Work Order ID 96191-2

January-24-13 7:59:05 AM

B 00

Item ID: D2360

D2360

Accept

Revision ID:

Item Name: Litter Tie Down Assembly

Start Date: 1/21/13 Start Qty: 4.00

4

Required Date: 2/06/13 Req'd Qty: 4.00

4

Reference:

Approvals: Process Plan: MLS

Date: 13-01-25 Tooling:

Date:

Run

Start

NR1

QC:

Date: SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100		0.00							
100	BAND SAW								
Bandsaw	Memo	0.00	PD	13/01/15		10	Ø		
Jeaspa Bandsaw	Cut blanks: 12.65" Long								
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine as per Folio D2341 and Dwg D2341 2-Deburr		F.T.	13/02/22		10	Ø		
			JFC/b.a	2013-02-23					

Page 1

800001

23 00

800010

23 00

Work Order ID 96191

January-24-13 7:59:05 AM

96191

Page 2

Item ID: D2360

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Litter Tie Down Assembly

Stop

NS2

Start Date: 1/21/13 Start Qty: 4.00 *4*

Required Date: 2/06/13 Req'd Qty: 4.00 *4*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

FK 13/02/22
JFC 13.02.2013-02-23
10 0

120

QC

Quality Control

130

QC8- Inspect parts - second check

0.00

29 3.2.25

10 1

130

QC

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

10 26.2.26

140

HandFinish

Hand Finishing

Memo

0.00



Work Order ID 96191

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Page 3

Item ID: D2360

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Litter Tie Down Assembly

Stop

NS2

Start Date: 1/21/13 Start Qty: 4.00

4

Required Date: 2/06/13 Req'd Qty: 4.00

4

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

150

Powdercoat

Powder Coating

White Gloss(Ref 4.3.5.1) per QSI005 4.3-Alum

M121295

0.00

10 φ ft 13-2-27.

160

160

QC

Quality Control

QC3- Inspect Part Finish

0.00

10X

JG 13/04/04

170

170

Small Fab

Small Fab

0.00

Memo

Assemble as per dwg D2360

(D4) 0.00
13.04.22

Open hole at .250



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Page 4

Item ID: D2360

Revision ID:

Item Name: Litter Tie Down Assembly

Start Date: 1/21/13 Start Qty: 4.00

Required Date: 2/06/13 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

Date: Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

(4) B-08-01 ID

190

190

Packaging

Packaging

Identify as per dwg & Stock Location: ST 221

0.00

R13/1/21 (4)

200

200

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

MLG B-08-09

Memo

0.00

MF
13-8-01



Picklist Print

January-24-13 7:59:03 AM

Page 1

Work Order ID: 96191

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 1/21/13

Required Date: 2/06/13

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP rev H 07.06.12 ecn 825 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C1032R18 Screw		Purchased	No			170	Each	593.0000	1	4	FF	13-07-30	
				<u>Location</u>			<u>Loc Qty</u>						
				FP001			93						
				4523			93						
				ST346			500						
				108079			400						
				110099			100						
AN960JD10 Washer	NAS1149D0363J	Purchased	No	124392		170	Each	0.0000	2	8	FF	13-07-30	
AN960JD10L Washer	NAS1149D0332J	Purchased	No	125807		170	Each	0.0000	8	32	FF	13-07-30	
D2002-015 Knob		Manufactured	No	98-241		170	Each	0.0000	2	8	FF	13-07-30	
D2345 Lock Channel		Manufactured	No			170	Each	21.0000	1	4	FF	13-07-30	
				<u>Location</u>			<u>Loc Qty</u>						
				GA	99626		21						
					86349		21						
D2366 Lock Handle		Manufactured	No			170	Each	22.0000	2	8	FF	13-07-30	
				<u>Location</u>			<u>Loc Qty</u>						
				ST009	98330		22						
					86351		3						
					89161		19						



Picklist Print

January-24-13 7:59:04 AM

Page 2

Work Order ID: 96191

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 1/21/13

Required Date: 2/06/13

Start Qty: 4.00

Required Qty: 4.00

D2367

Handle Knob

Manufactured

No

170

Each

13.0000

1

4

PF 13-07-30

Location

ST009 95711
83541
89083

Loc Qty

13
1
12

Loc Code

4

D2372

Quick Release

Manufactured

No

170

Each

15.0000

2

8

FF 13-07-30

Location

GA 99010
97040
86001
92199

Loc Qty

15
2
13

Loc Code

3

D2373

Spring

Manufactured

No

170

Each

19.0000

1

4

FF 13-07-30

Location

ST009 98341
86352

Loc Qty

19
19

Loc Code

1
3

D2444

Pip Pin Assembly

Manufactured

No

170

Each

3.0000

1

4

FF 13-07-30

Location

GA 98455
88498

Loc Qty

3
3

Loc Code

1

D6201

"T" Extrusion

Manufactured

No

100

f

46.4586

1.054

4.4378948

PD 13/02/15

Location

MAT028 46,45863153
81421 13.1586315
83987A 20
89645 13.3

Loc Qty

46,45863153
13.1586315
20
13.3

Loc Code

3.2
7.5

end of batch

untl not
fitted



Picklist Print

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Page 3

Work Order ID: 96191

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 1/21/13

Required Date: 2/06/13

Start Qty: 4.00

Required Qty: 4.00

MS20470AD3-4

Rivet,Universal Head

Purchased

No

170

Each

8,602.0000

1

4

FF 13-07-30

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

GA	270	
----	-----	--

15541

	270	
--	-----	--

ST319	8332	
-------	------	--

111477

	8332	
--	------	--

MS21042L3

Nut

Purchased

No

170

Each

7,678.0000

3

12

FF 13-07-30

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP001	<u>126036</u>	
-------	---------------	--

122141

	3	
--	---	--

GA	434	
----	-----	--

122452

	434	
--	-----	--

ST314	268	
-------	-----	--

117885

	32	
--	----	--

119017

	55	
--	----	--

119075

	138	
--	-----	--

123265

	43	
--	----	--

ST506	6973	
-------	------	--

123900

	2973	
--	------	--

124291

	4000	
--	------	--

X MS27039-1-13

Screw

Purchased

No

170

Each

568.0000

1

4

FF 13-07-30

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

GA	16	
----	----	--

119736

	16	
--	----	--

ST304	52	
-------	----	--

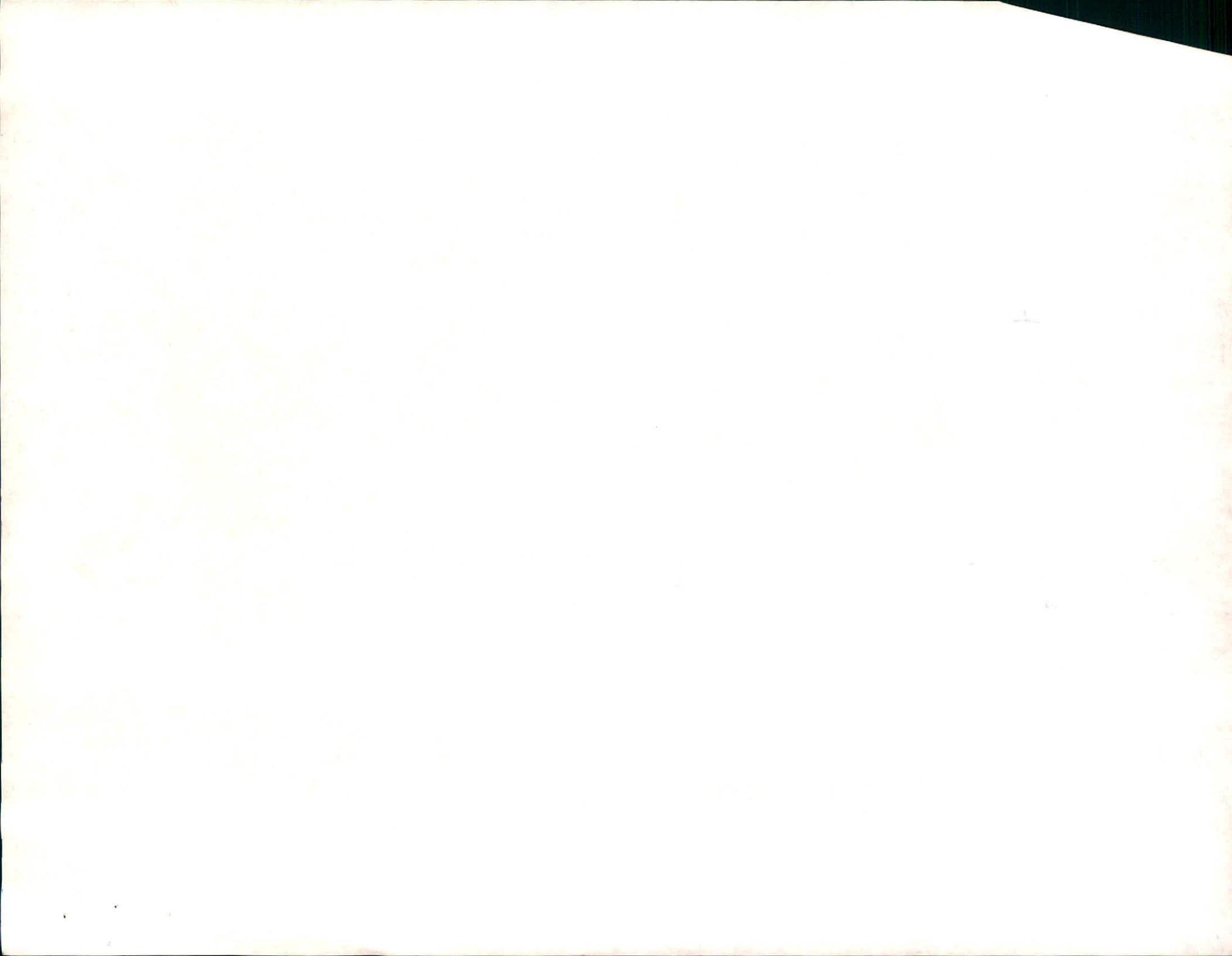
119736

	52	
--	----	--

ST506	500	
-------	-----	--

124326

	500	
--	-----	--



Picklist Print

January-24-13 7:59:04 AM

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Work Order ID: 96191

Parent Item: D2360

Parent Item Name: Litter Tie Down Assembly

Start Date: 1/21/13

Required Date: 2/06/13

Start Qty: 4.00

Required Qty: 4.00

MS27039-1-15

Purchased

No

170

Each

1,078.0000

2

8

FF

13-07-30

Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST305	78	
-------	----	--

123352	78	
--------	----	--

ST506	1000	
-------	------	--

124326	1000	
--------	------	--

NAS679A3W

Nut

Purchased

No

170

Each

184.0000

1

4

FF

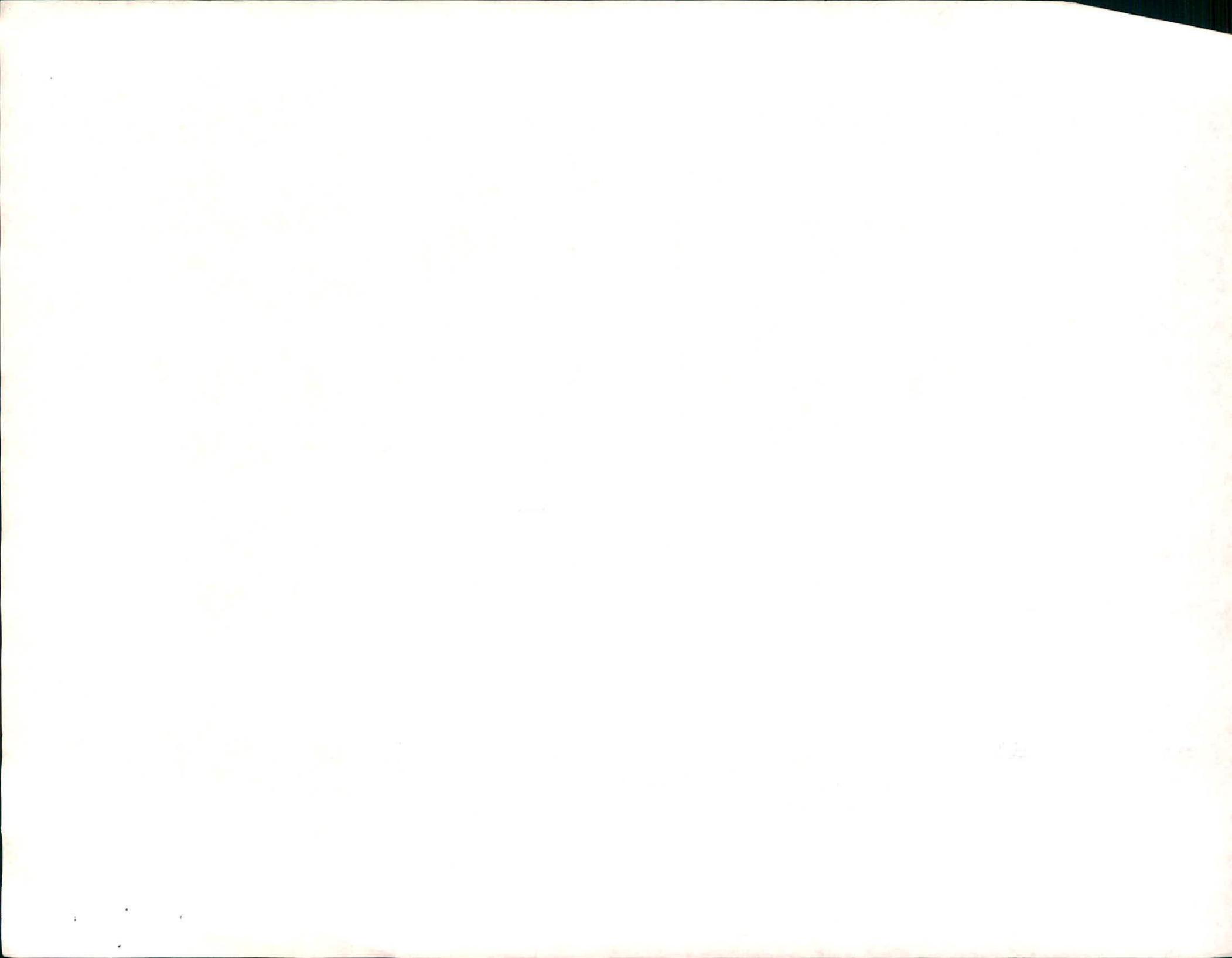
13-07-30

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

GA	5	
----	---	--

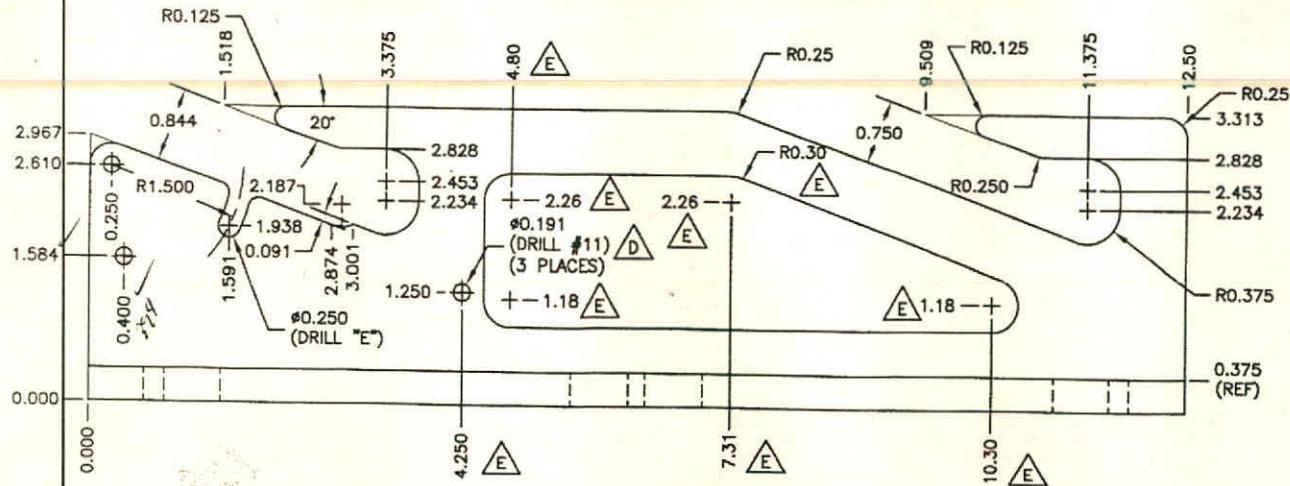
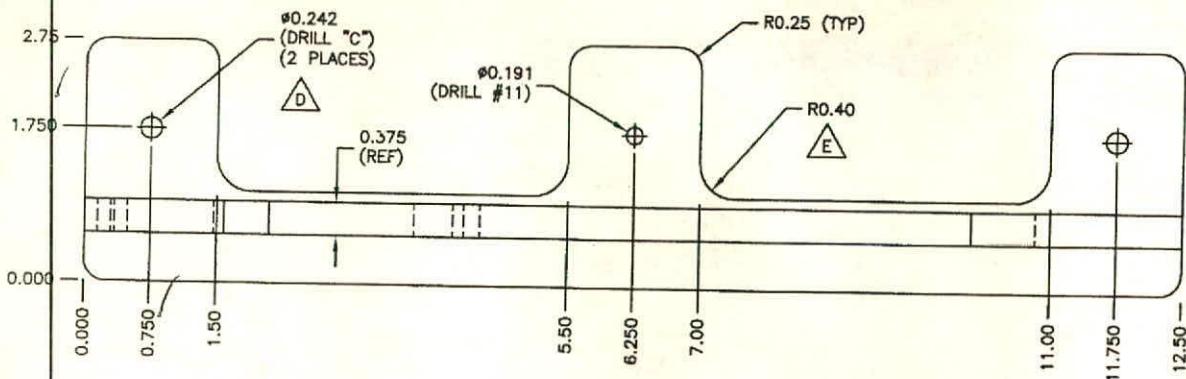
1463	5	
------	---	--

2409	179	
------	-----	--



DART

DESIGN BW	DRAWN BY <i>JG</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>MM</i>	DRAWING NO. D2341	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER TIE DOWN BRACKET (LOCKING)	SCALE 1:2
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	REVISED NOTES; FINISH WAS ANODIZE	



D2341 LITTER TIE DOWN BRACKET (LOCKING)

- 1) MATERIAL: MAKE FROM D6201-D125 EXTRUSION (6061-T6/T651 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT PERMANENT INK MARKER

RELEASED

07-06-22 *[Signature]*

16196

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED CE	APPROVED dt	DRAWING NO. D2360	REV. D SHEET 1 OF 2	
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	SCALE	
A	95.02.10	NEW ISSUE		
B	95.02.20	RE-DESIGN		
C	97.08.27	ADD MS20470AD3-4 RIVET		
D	07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)		

RELEASED

07.06.06

PARTS LIST:

QTY	PART NUMBER	DESCRIPTION
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

D

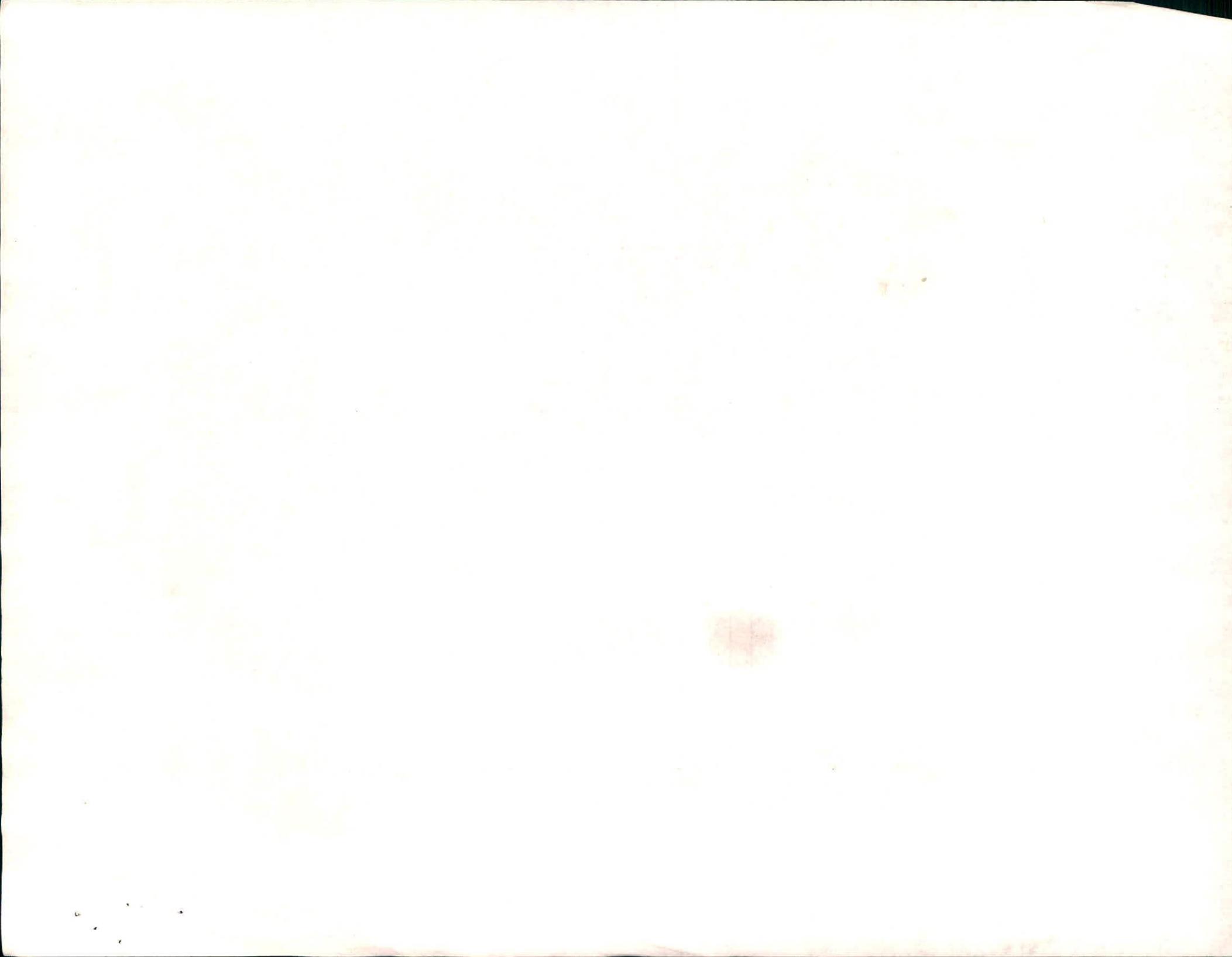
D

D

96191 MLC
130125

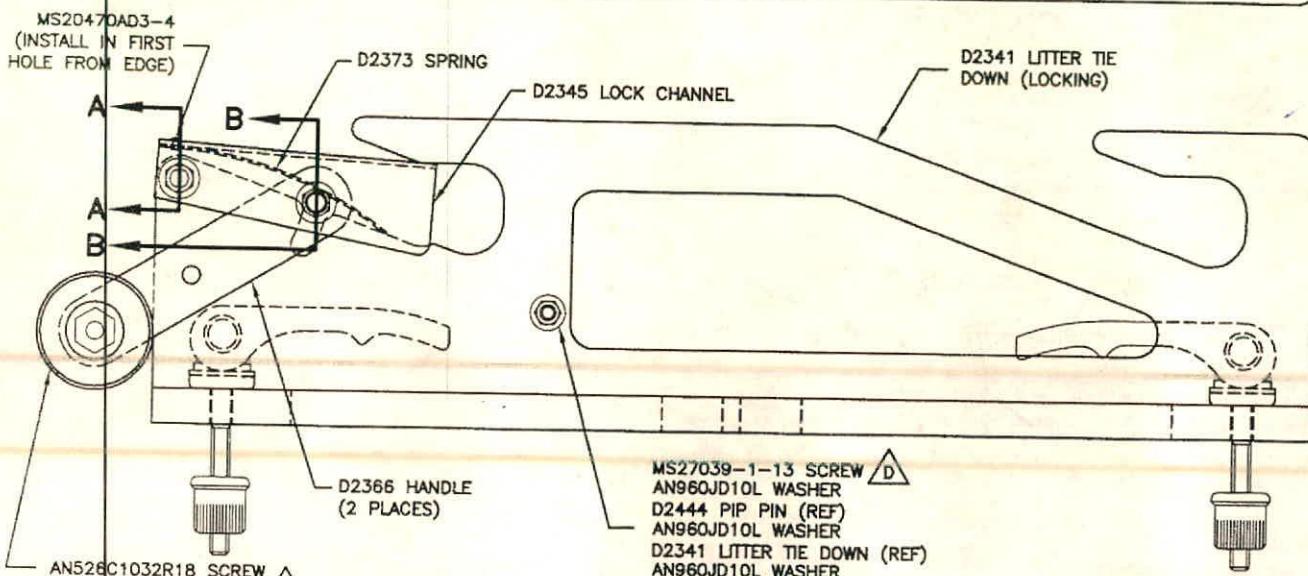
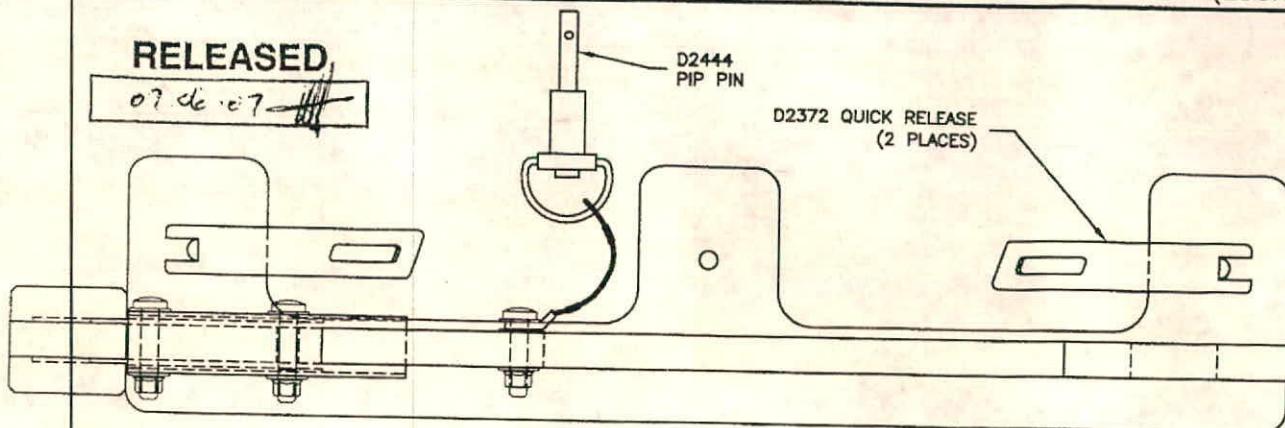
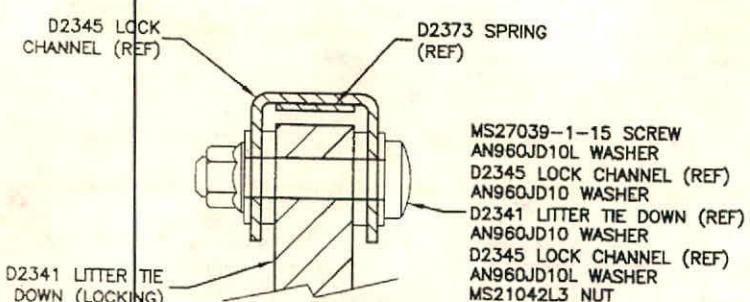
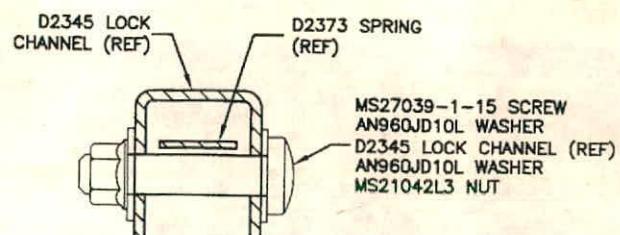
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DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>MM</i>	DRAWING NO. D2360	REV. D SHEET 2 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	SCALE

RELEASED07.06.07 *[Signature]***D2360 LITTER TIE DOWN ASSEMBLY (LOCKING)****SECTION A-A**
(SCALE 1:1)**SECTION B-B**
(SCALE 1:1)

16/09



DART AEROSPACE LTD		Work Order:	96191
Description: Litter Tie Down Bracket (Locking)		Part Number:	D2341
Inspection Dwg: D2341	Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1.742	/		FK-04	Vern.
2.75	+/-0.030	2.752	/			"
.00.242	+0.005/-0.001	.242	/			"
.00.191	+0.005/-0.001	.191	/			"
R0.25	+/-0.030	.25	/	/		"
R0.40	+/-0.030	.40	/	/		"
12.50	+/-0.030	12.750	/		FK-05	Tape.
11.750	+/-0.010	11.750	/	/	CNC-02	Vern.
11.00	+/-0.030	11.00	/	/	FK-05	Type
7.00	+/-0.030	7.00	/	/	CNC-02	Vern.
6.250	+/-0.010	6.25	/	/		"
5.50	+/-0.030	5.50	/	/		"
1.50	+/-0.030	1.50	/	/	FK-04	Vern.
0.750	+/-0.010	.752	/	/		"
0.400	+/-0.010	.399	/	/		"
1.584	+/-0.010	1.584	/	/		"
2.610	+/-0.010	2.610	/			"
0.250	+/-0.010	.249	/			"
0.844	+/-0.010	.842	/			"
.00.250	+/-0.010	.249	/			"
0.750	+/-0.010	.750	/			"
3.313	+/-0.010	3.312	/			"
4.250	+/-0.010	4.250	/			"
1.250	+/-0.010	1.247	/			"

Measured by:	FK..	Audited by:	Rf	Prototype Approval:	N/A
Date:	13/02/22	Date:	13.2.25	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	10.02.02	Dimensions updated	KJ	

